



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3403-1
Job Sheet 173623



Part No: D3403-1

Job Qty: 20 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/7/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A 05.08.31 New issue KJ/JLM IPP Rev:B 06-03-07 As per Rev B JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	3/6/18	3/6/18	0.00	0.00	Start Up Machining-2	97ML	J.B. 18-03-06
100	Hardinge	20 pcs	3/7/18	3/7/18	0.08	2.57	Hardinge	97ML	J.B. 18-03-06
120	QC	20 pcs	3/7/18	3/7/18	0.00	0.00	QC8		J.C.L.
130	Packaging	20 pcs	3/7/18	3/7/18	0.00	0.00	Packaging3-1	ST033	
140	QC21-SA	20 Ea	3/7/18	3/7/18	0.00	0.00	QC21		MAR 06 2018

Part Op
Descriptions: 100 - 1- Turn as per Folio FA556 & Dwg D3403 Folio Rev: _____ Dwg Rev: _____

MAR 07 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.750	TBD	4.3400 (.217 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R0.750	4	0	0



Container No: S048705



Part: D3403-1

Job No: 173623

Serial No/Batch: S048705

Revision:
Inspector:

Date: 03/07/18

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DQA: _____ Date: _____

QA Closed: **DAS 53** 9-89 Date: **MAY 25 2018****WORK ORDER NON-CONFORMANCE / UPDATE**Work Order update only ☐

Work Order: <u>173623</u> Part No. <u>D3403-1</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☒</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☒</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☒</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☒	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☒	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																	
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Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type
1	Bushing	2.360inches + 0.010 - 0.000	2.370 2.360	
2	Bushing	0.060inches ± 0.005	0.065 0.055	
3	Bushing	0.257inches + 0.010 - 0.000	0.267 0.257	
4	Bushing	0.750inches ± 0.010	0.760 0.740	
5	Bushing	0.425inches + 0.000 - 0.002	0.425 0.423	
6	Bushing	0.030inches ± 0.010	0.040 0.020	
7	Bushing	20.0Degrees ± 0.5	20.5 19.5	
8	Bushing	0.313inches ± 0.010	0.323 0.303	
9	Bushing	60.0Degrees ± 0.5	60.5 59.5	

Plex 3/6/18 8:38 AM dart.lacelle.linda

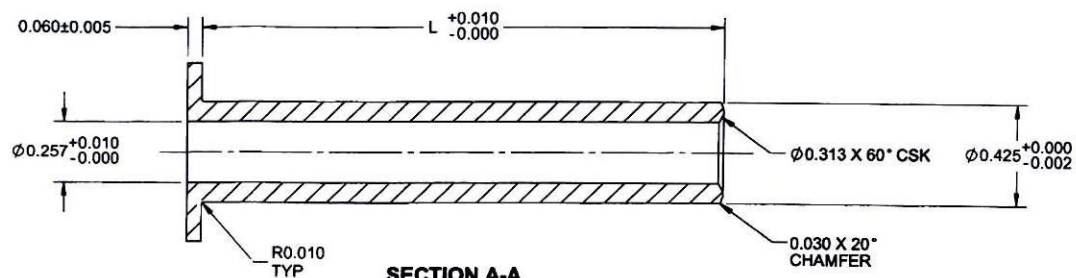
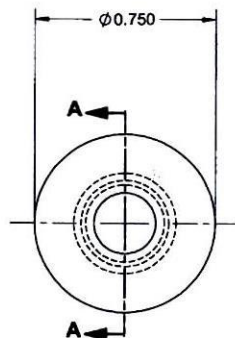
DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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SECTION A-A

D3403-X BUSHING

DART P/N	L	WEIGHT (LBS)
D3403-1	2.360	0.07
D3403-3	2.165	0.06
D3403-5	2.420	0.07

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR
PER ASTM A582
REF. DART SPEC. M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

E	D3403-1 WAS 2.416, D3403-5 WAS 2.440 REASON: CAR15-109	ML	16.02.23
D	FOR-5, 2.440 WAS 2.500 (PER PAR 11-125)	XDF	11.10.28
C	REFORMAT TO CURRENT STD PER QSI 043; ADDED D3403-5. TOL WAS +0.005/-0.000. REASON: PAR#10-029	MB	10.04.21
B	ADD COUNTERSINK	PH	06.01.23
A	NEW ISSUE	PH	05.03.07
REV.	DESCRIPTION	BY	DATE

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	JLM	D3403	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BUSHING	NTS
DATE	16.02.23	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2016-04-28
EN 11-516

APPROVED



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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S048705



Part: D3403-1

Job No: 173623

Serial No/Batch: S048705

Revision:

Inspector:

Date: 03/07/18